

Date: Thursday, 10/11/2007 2:51:05 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TUBE ASSEMBLY
Job Number : 35111
Estimate Number : 12183
P.O. Number : N/A
This Issue : 10/11/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 28556
Written By :
Checked & Approved By :
Comment : Est Rev. A New Issue 06-02-03 JLM

Part Number : D3469043
Drawing Number : D3469 REV A1
Project Number : N/A
Drawing Revision : A1
Material : N/A
Due Date : 10/25/2007 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D34691 TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3469-1 Tube

B35141

B35141

6mx

mf

mf

2.0 D34695 LOWER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

LOWER PLATE

Batch: B34409

B34409

3mx

mf

mf

3.0 AN960C416L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN960C416L Washer

M104936

M104936

12mx

mf 07-12-05

~~mf 07-11-19~~

mf 07-10-22

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469 Using Dt8849 Assembly Jig, Use 1/4" Shaft To Align Butterfly Shaft holes

2-Spot Weld as per Dwg D3469 and Dart QSI 018

pto lost page

mf 07-12-05

mf 07-10-22

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 35111

Part Number: D3469043

Job Number:



Seq. #: Machine Or Operation: Description:

5.0

QC#1

VISUAL WELDING INSPECTION

RE



SB 07/12/05

(2)

Comment: VISUAL WELDING INSPECTION

SB 07/10/22

(1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



SB 07/12/05

(2)

Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/22

(1)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 07/12/05

(2)

SB 07/10/22

(1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Don 10/10/04

(2)

(1)

Comment: FINAL INSPECTION/W/O RELEASE

Don 10/10/03

Job Completion

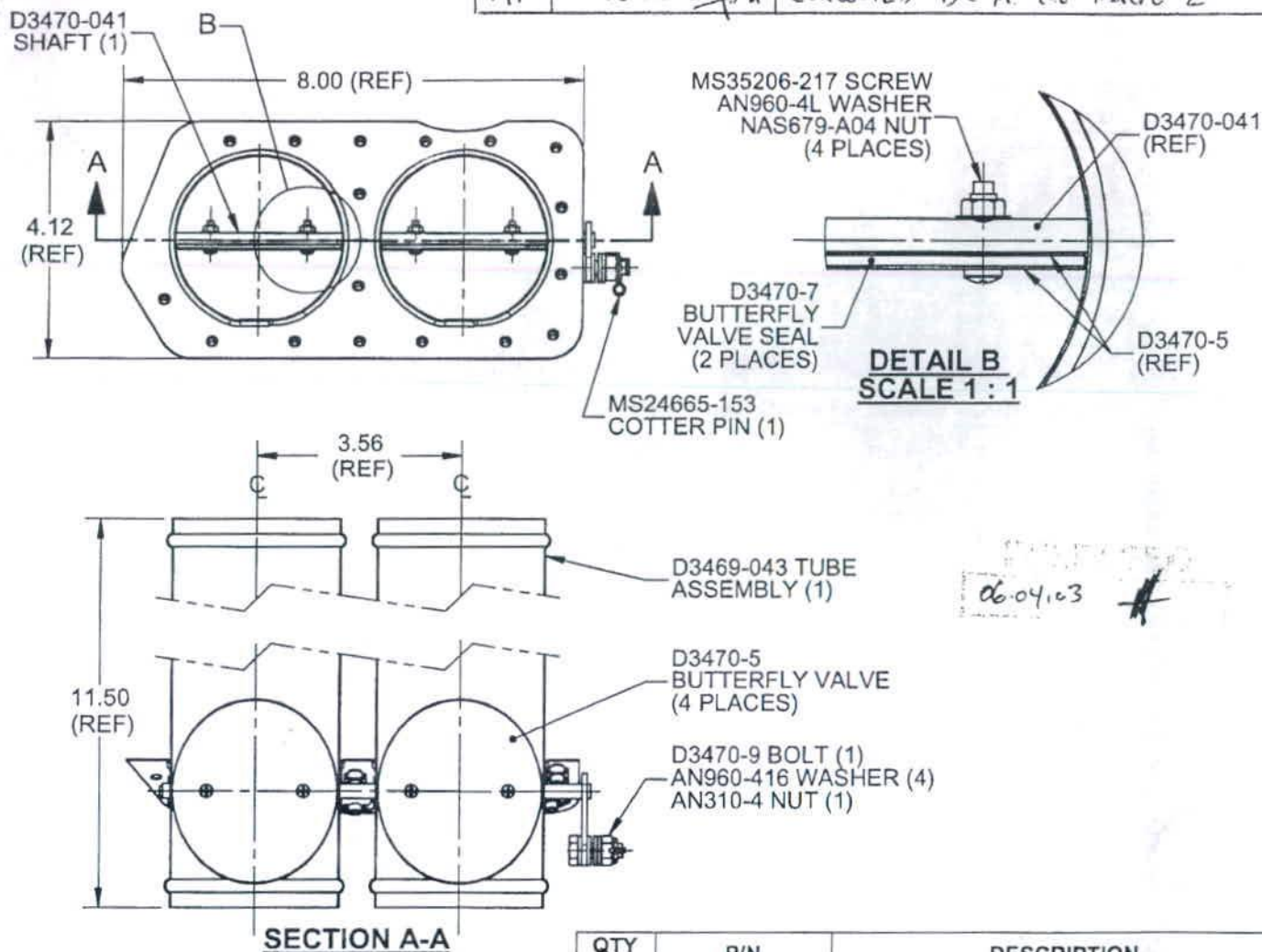


12/07/03

12/07/05 (2)



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED BOM on PAGE 2	



D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

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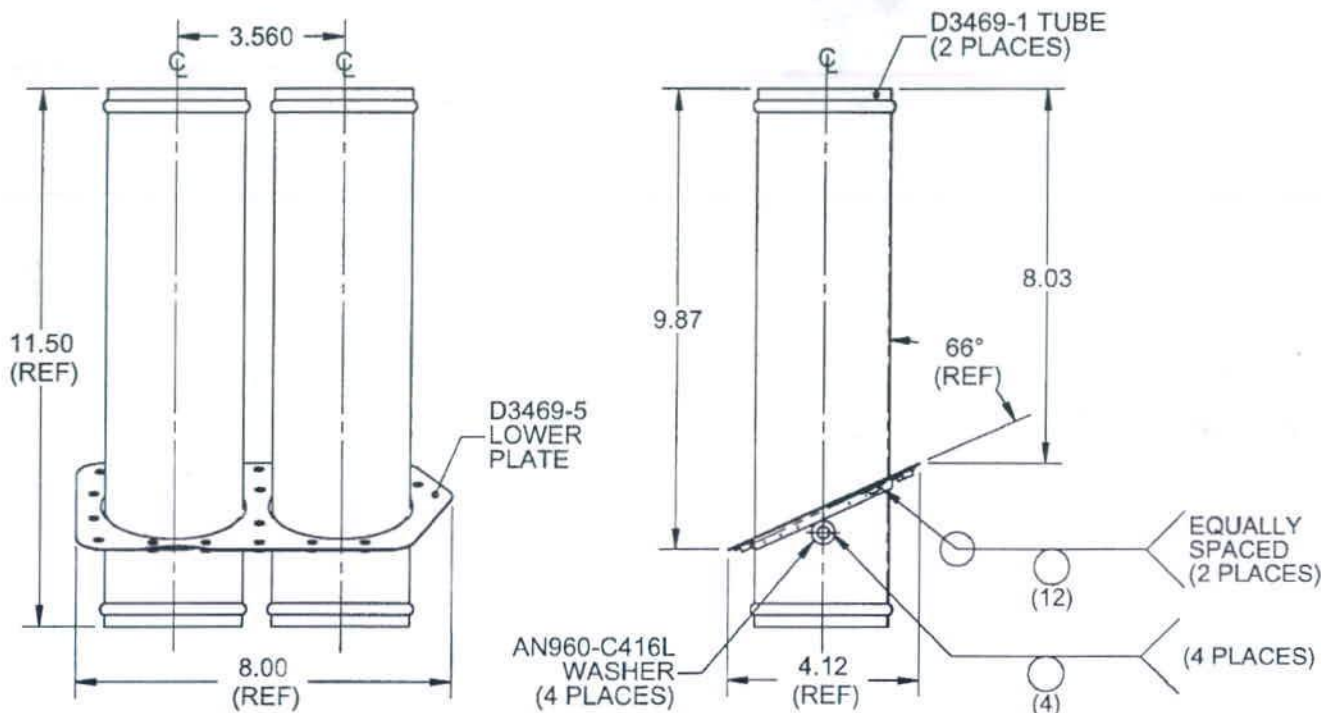
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CHECKED #	APPROVED #	DRAWING NO. D3469	REV. A SHEET 2 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

06.04.03



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D3469-043 TUBE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

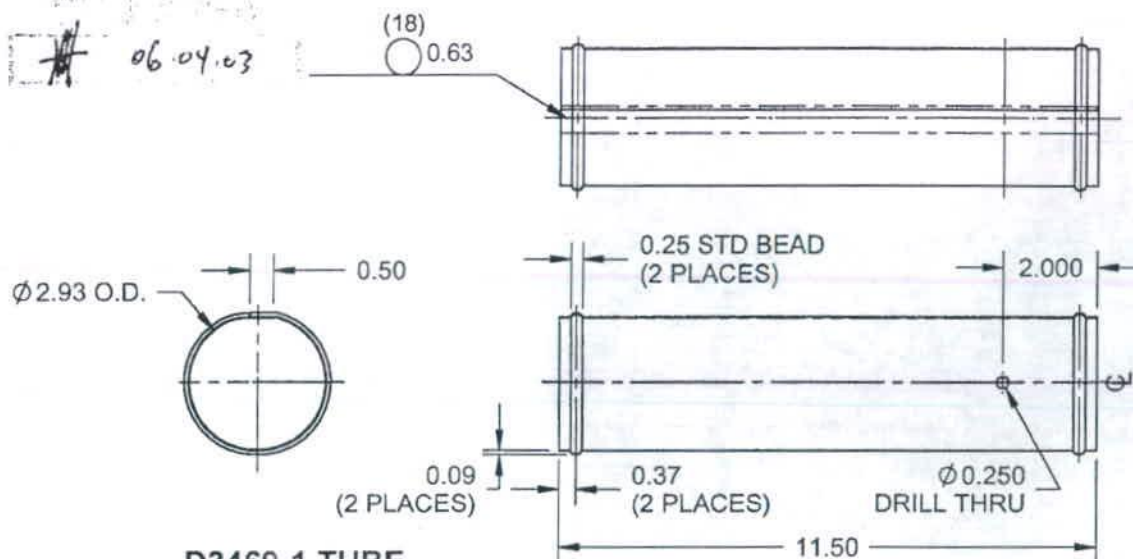
QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	D3470-5	PLATE VALVE
4	AN960-C416L	WASHER

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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4



D3469-1 TUBE



D3469-1F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

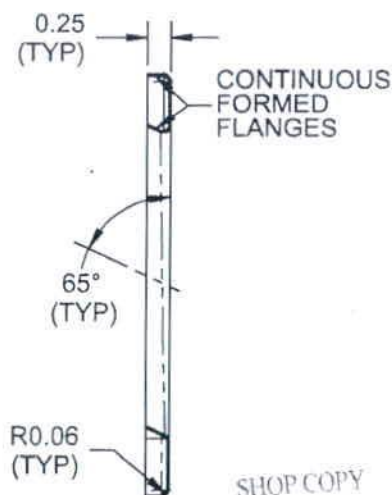
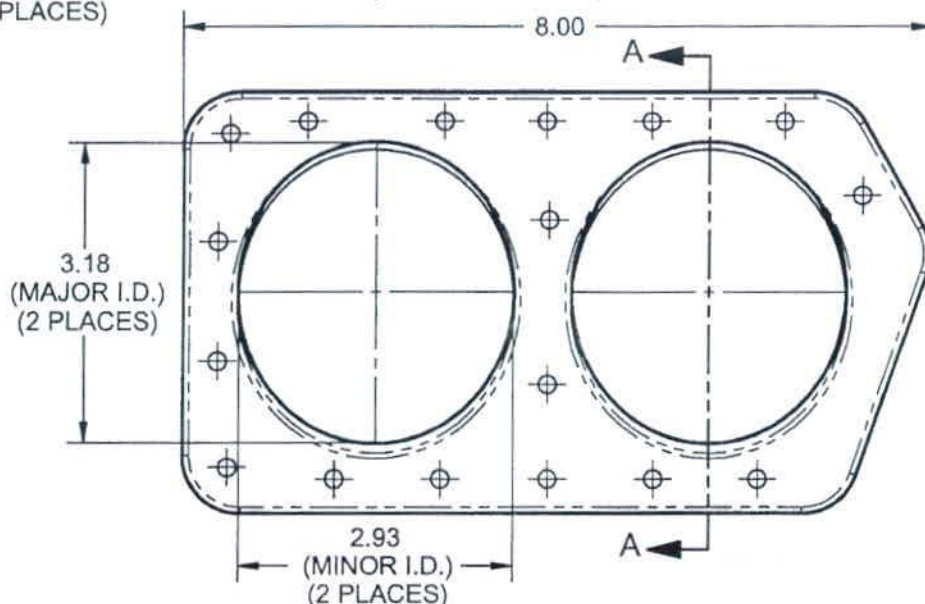
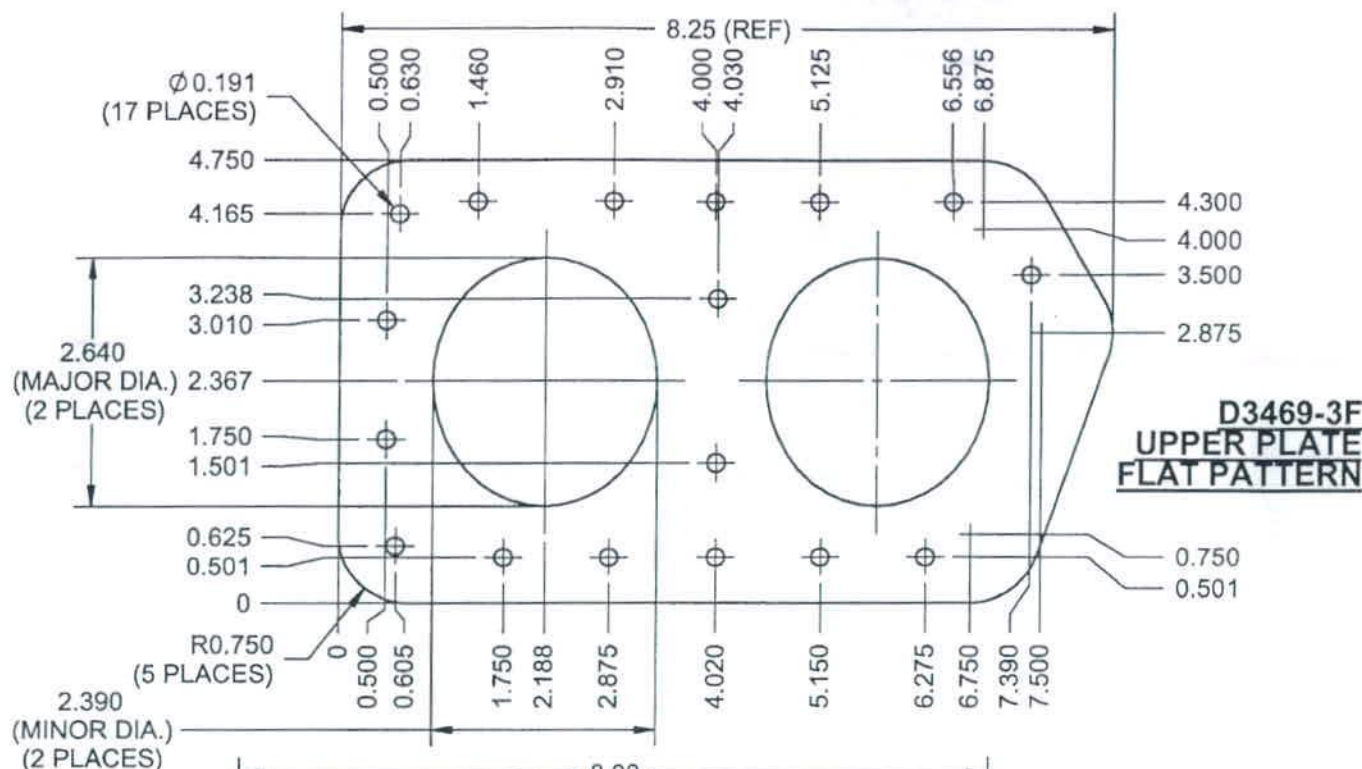
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



D3469-3 UPPER PLATE BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

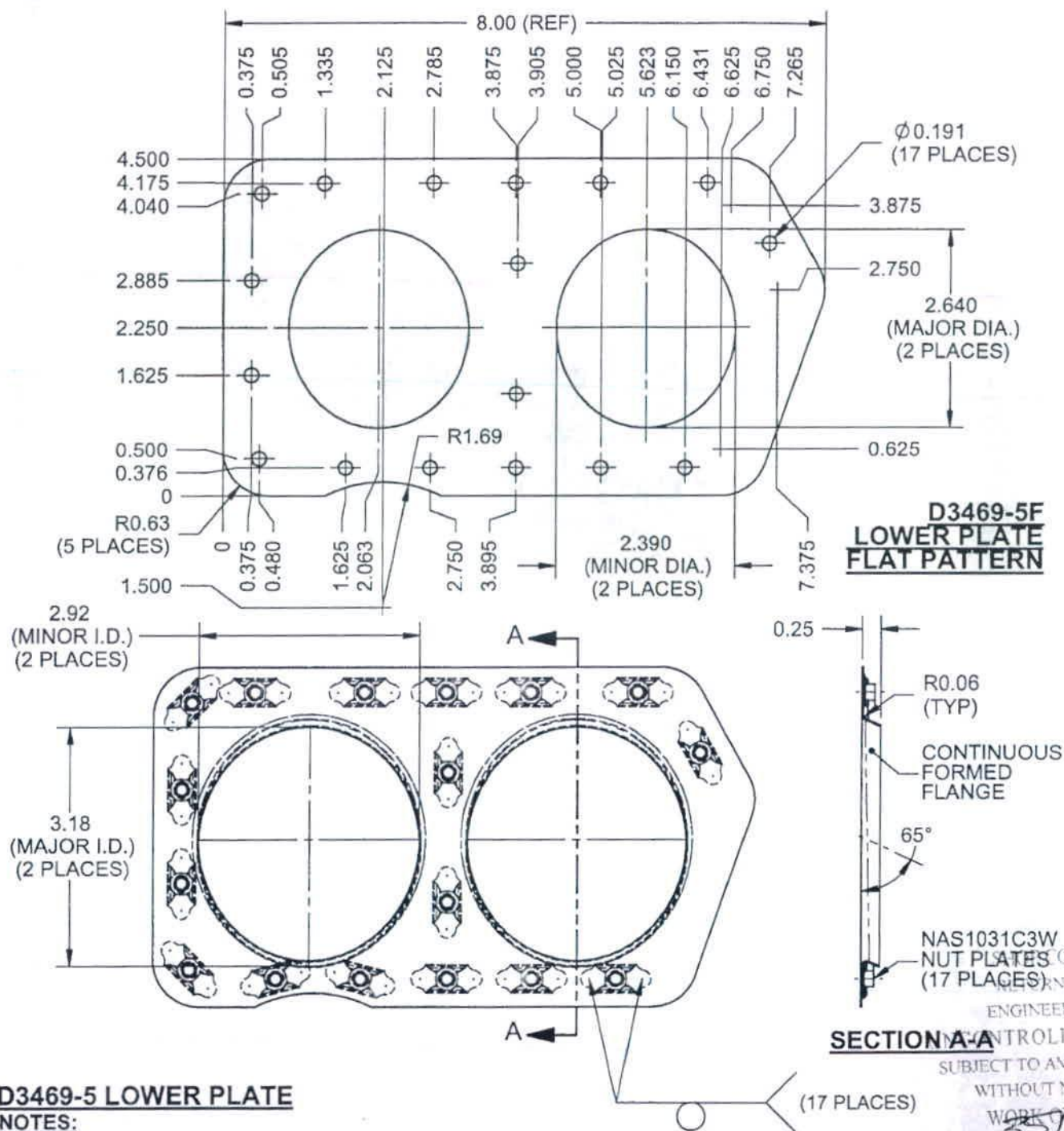
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	
		SCALE 1:2	



D3469-5 LOWER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 46

EMPLOYEE: Melanie Patten

PART NUMBER: D 3469-043

JOB NUMBER: B3511

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL	
VISUAL:	[<u>✓</u>]	[]	
PENETRATION:	[<u>✓</u>]	[]	
PULL STRENGTH:	[<u>✓</u>]	[]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)





DATE OF TEST COUPON: 07/12/05
QUALIFIER: SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-12-05	4						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-05	4	- spot weld made hole in tube		- scrap + destroy No Replacement	mk 07-12-05			

NOTE: Date & initial all entries

